

Work Order ID 58451 - 2

May 7, 2010 10:08:38 AM

Page 1

Item ID: D3572-041

Revision ID:

Item Name: Guide Assembly

Start Date: 07/05/2010 Start Qty: 10.00

Required Date: 14/05/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date: 10-5-09 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3572

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EL 10-5-10

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

EL 10-5-10

120

QCS- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sidewall

(TIC)

Work Order ID 58451

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Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 07/05/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> m k 10/06/07 (4X)

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

Powder Coating

START TIME: 11:45am
OVEN TEMPERATURE: 320°F
FINISH TIME: 12:15pm

=> M 10/06/10

4 8

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

m 10 06 10 (4)

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Page 4

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 07/05/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

10-6-11 (4) SD

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/14 JJ

C21016111

Picklist Print

May 7, 2010 10:08:43 AM

Page 1

Work Order ID: 58451

Parent Item: D3572-041

Parent Item Name: Guide Assembly

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B revB dwg EC
IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM
IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Start Date: 07/05/2010

Required Date: 14/05/2010

Start Qty: 10.00

Required Qty: 10.00

M6061T6T1.000W.188

Purchased No

110

f

121.7490

2.34



6061T6 RD TUBE 1.00 X .188W



EL 10-5-10

Location

Loc Qty

Loc Code

MAT

48

114520

48

MAT016

73.749

113511

26.916

114089

46.833

D3572-3

Manufactured No

130

Each

24.0000

4



Guide



EL 10-6-3

Location

Loc Qty

Loc Code

ST244

24

55725

24

D3572-5

Manufactured No

130

Each

24.0000

1



Bracket



EL 10-6-3

Location

Loc Qty

Loc Code

WA

24

54119

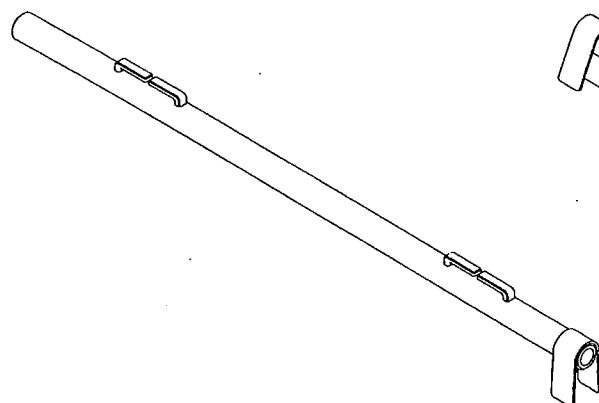
24

4

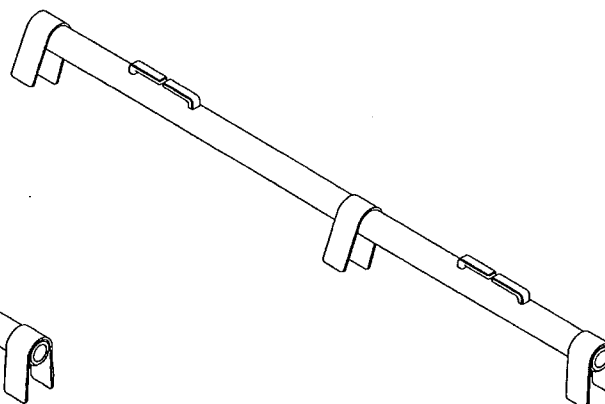
| ITEM No. | QTY -041 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|----------|----------|----------|----------|-------------|-----------------------------|
| 1 | X | | | D3572-041 | GUIDE ASSEMBLY |
| 2 | | X | | D3572-043 | GUIDE ASSEMBLY (UH-1) |
| 3 | | | X | D3572-044 | GUIDE ASSEMBLY (UH-1) (OPP) |
| 11 | 1 | 1 | 1 | D3572-1 | TUBE |
| 12 | 4 | 4 | 4 | D3572-3 | GUIDE |
| 13 | 1 | 3 | 3 | D3572-5 | BRACKET |
| 14 | - | - | - | D3572-7 | DELETED AT REV C |

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58451
BJ 10-5-07

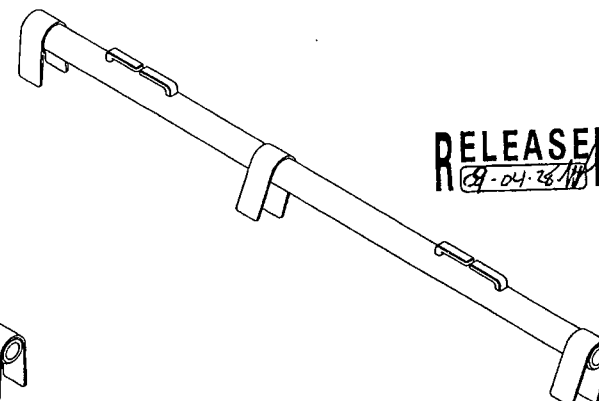
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09-04-28/17



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)

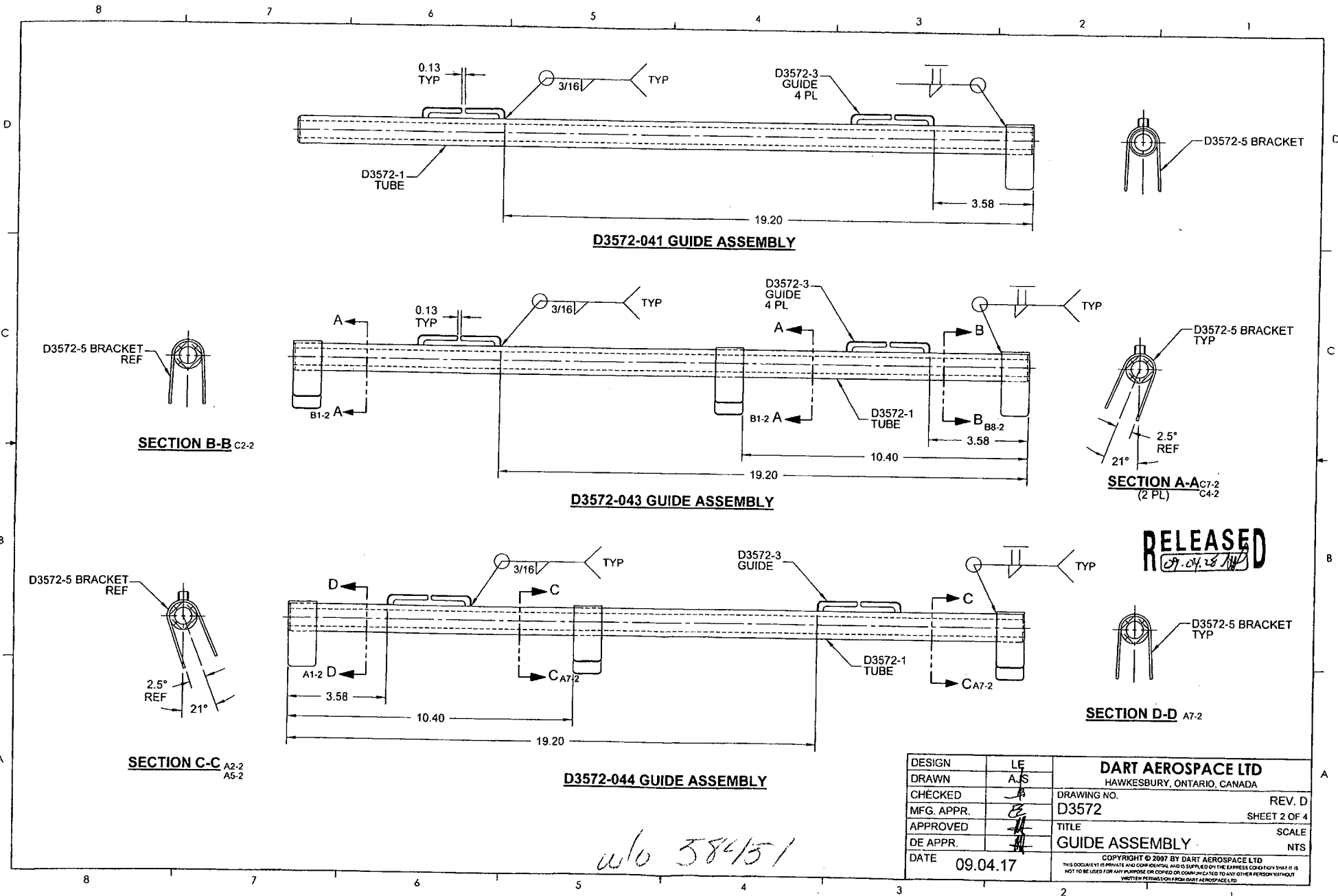


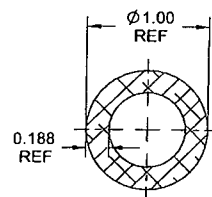
D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

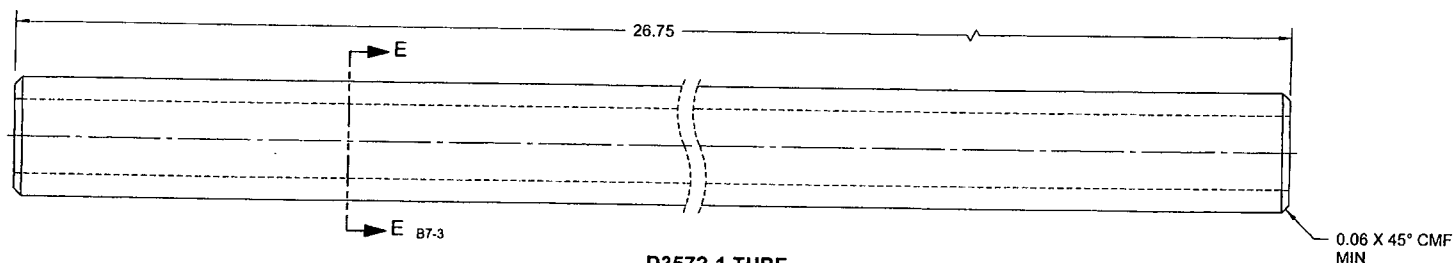
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

| | | | |
|------------|---|---|----------|
| D | REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017. | AJS | 09.04.17 |
| C | REMOVE D3572-7 | LE | 07.06.01 |
| B | FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET | LE | 07.04.20 |
| A | NEW ISSUE | LE | 07.03.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3572 GUIDE ASSEMBLY <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |
| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | | |
| MFG. APPR. | <i>[Signature]</i> | | |
| APPROVED | <i>[Signature]</i> | | |
| DE APPR. | <i>[Signature]</i> | REV. D SHEET 1 OF 4 SCALE NTS | |
| DATE | 09.04.17 | | |





SECTION E-E C5-3



D3572-1 NOTES:

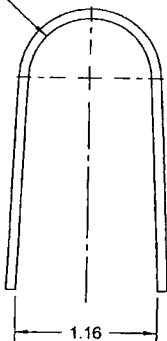
- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3572 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GUIDE ASSEMBLY | NTS |
| DATE | 09.04.17 | COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

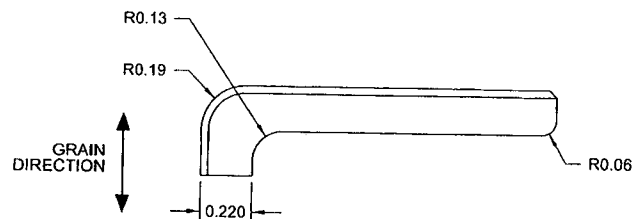
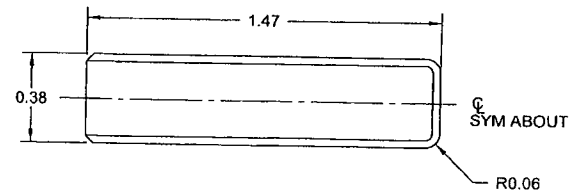
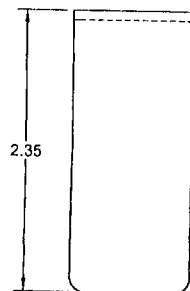
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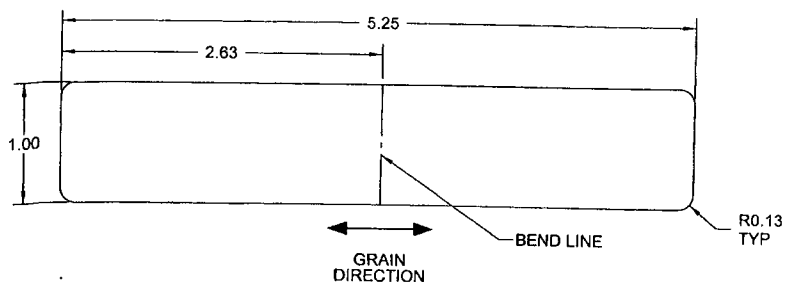
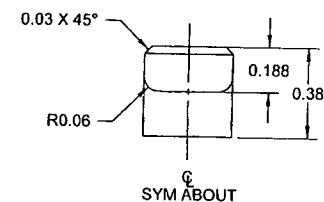
R0.50



D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-3 GUIDE



D3572-5F FLAT PATTERN

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AS | | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3572 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GUIDE ASSEMBLY | NTS |
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